

ABSTRACT OF THE DISCLOSURE

A load cell deflasher for the punch and die deflash processing of product from an extrusion includes a load cell pressure transducer interconnected with a punch to sense pressure measurements of the punch against the extrusion at the die and communicate the measurements to a programmable logic controller that controls the extension and retraction of the punch to the die and the structure accommodating pre-punch alignment of the extrusion to the die. The pressure measurements are logged in a trending database of the programmable logic controller. If a pressure measurement exceeds a threshold value, the programmable logic controller can command instruct a positioning actuator of the punch to abort its punch stroke prior to completion. If the programmable logic controller determines an upward trend of pressure measurements, an auto-tune mode of the programmable logic controller can command instruct an extrusion card transfer positioning actuator to adjustably position a gripper carriage transferring the extrusion in intervening proximity between the punch and die to an optimal position for extrusion deflashing.